

Work Order ID 60454

Friday, July 09, 2010 9:53:29 AM



Page 1

Item ID: D3769-1

Accept



Setup Start



Revision ID:

Item Name: Tube

Stop



Start Date: 7/12/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: *10-7-9*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3769

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3769 2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig 3- deburr

6X

=> m-h 10/07/04

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. 10/07/14

(46)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 BR 10-7-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

JES

10/07/11

6

0



QC

Memo

Quality Control

0.00

140

Identify as per dwg & Stock Location: 250A

0.00



Packaging

Memo

Packaging

0.00

10/07/11 (6)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

1007-15
MF
10-7-14

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Picklist Print

Friday, July 09, 2010 9:53:28 AM

Page 1

Work Order ID: 60454

Parent Item: D3769-1

Parent Item Name: Tube



Start Date: 7/12/2010

Required Date: 7/16/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065 		Purchased	No			100	f	64.8842	1.204	7.604211			
6061T6 RD TUBE 1.00 x .065w													

Location

MAT015

113511 ✓

114089

Loc Qty

64.88421

52.88421

12

Loc Code

7-604211

10/07/14

M.H

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

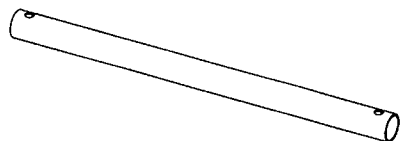
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

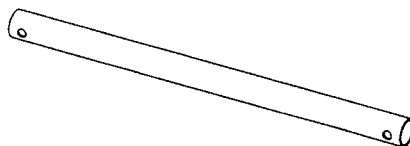
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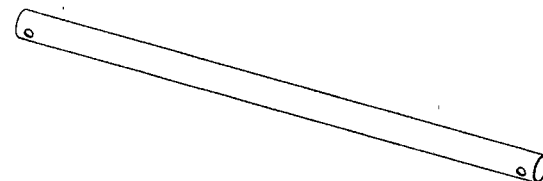
60454



D3769-1 TUBE



D3769-3 TUBE



D3769-5 TUBE

RELEASED
08.06.04

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD		
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>[Signature]</i>	D3769	SHEET 1 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	TUBE	NTS	
DATE	08.06.04			

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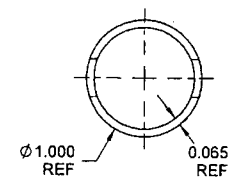
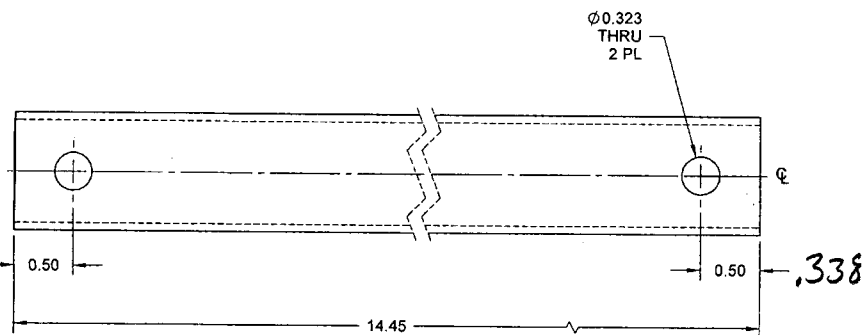
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D3769-1 TUBE

RELEASED
08-06-14

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>Ref</i>	DRAWING NO. D3769	REV. A
MFG. APPR.	<i>NS</i>		SHEET 2 OF 4
APPROVED	<i>Ref</i>	TITLE	SCALE
DE APPR.	<i>Ref</i>	TUBE	NTS
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